

Work Order ID 48541

June 26, 2009 7:33:25 AM



Page 1

Item ID: D3293-1 **BK**

Revision ID: A

Item Name: Doubler

Start Date: 15/07/2009 Start Qty: 8.00

Required Date: 03/08/2009 Req'd Qty: 8.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3293

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3293
Deburr if necessary

Dwg Rev: A Prog Rev: A 1/2-

HB 9-6-30

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

HB 9-6-30

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

→ 508/07/01 (48)

(8)

Work Order ID 48541

June 26, 2009 7:33:25 AM



Page 2

Item ID: D3293-1

Revision ID: A

Item Name: Doubler

Start Date: 15/07/2009 Start Qty: 8.00

Required Date: 03/08/2009 Req'd Qty: 8.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo
1/ Debur

u/45

0.00

0.00

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

= 803/07/01 (KS)

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

- umd 09/07/01 (K8)

Work Order ID 48541

June 26, 2009 7:33:25 AM



Item ID: D3293-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Doubler

Start Date: 15/07/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 2:00pm OVEN TEMPERATURE:

2:30pm FINISH TIME:

3200K

M109091 J11 09-07-01 (8)

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

180

Identify as per dwg & Stock Location 211

0.00



Packaging

Memo

0.00

Packaging

9/7/2 50

(8x)

Work Order ID 48541

June 26, 2009 7:33:25 AM



Page 4 -

Item ID: D3293-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Doubler

Start Date: 15/07/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/08
MF 09-07-07

Picklist Print

June 26, 2009 7:33:24 AM

Page 1

Work Order ID: 48541

Parent Item: D3293-1RevA

Parent Item Name: Doubler



Comments:

Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.080		Purchased	No			100	sf	0.0000	15.3802			
												
2024-T3 .080 sheet												

m 110347

B 9-630

Date: Friday, 12/06/2009 9:55:12 AM
User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER
Job Number	: 48541		
Estimate Number	: 11178		
P.O. Number	:	Part Number	: D32931
This Issue	: 12/06/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3293 REV A
First Issue	: / /	Project Number	: N/A
Previous Run	: 45817	Drawing Revision	: A
	Type	Material	:
	: SMALL /MED FAB	Due Date	: 19/06/2009
Written By	:	Qty:	8
Checked & Approved By	: <u>Julie Dawson</u>	Um:	Each
Comment	: Est:A 04.08.24 New issue KJ/JLM Est Rev:B Now on Waterjet 06-11-02 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M2024T3S080	2024-T3 .080 sheet
-----	-------------	--------------------



Comment: Qty.: 1.9177 sf(s)/Unit Total : 15.3418 sf(s)
Material: 2024-T3 (QQ-A-250/4) 0.080" thick
(M2024T3S.080)
Identify for D3293-1
Batch: 110347 HB 9-6-30

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
1-Cut as per Dwg D3293
Dwg Rev: A
Prog Rev: A

HB 9-6-30

2-Deburr if necessary

HB 9-6-30

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 12/06/2009 9:55:12 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 48541

Part Number: D32931

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Deburr

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

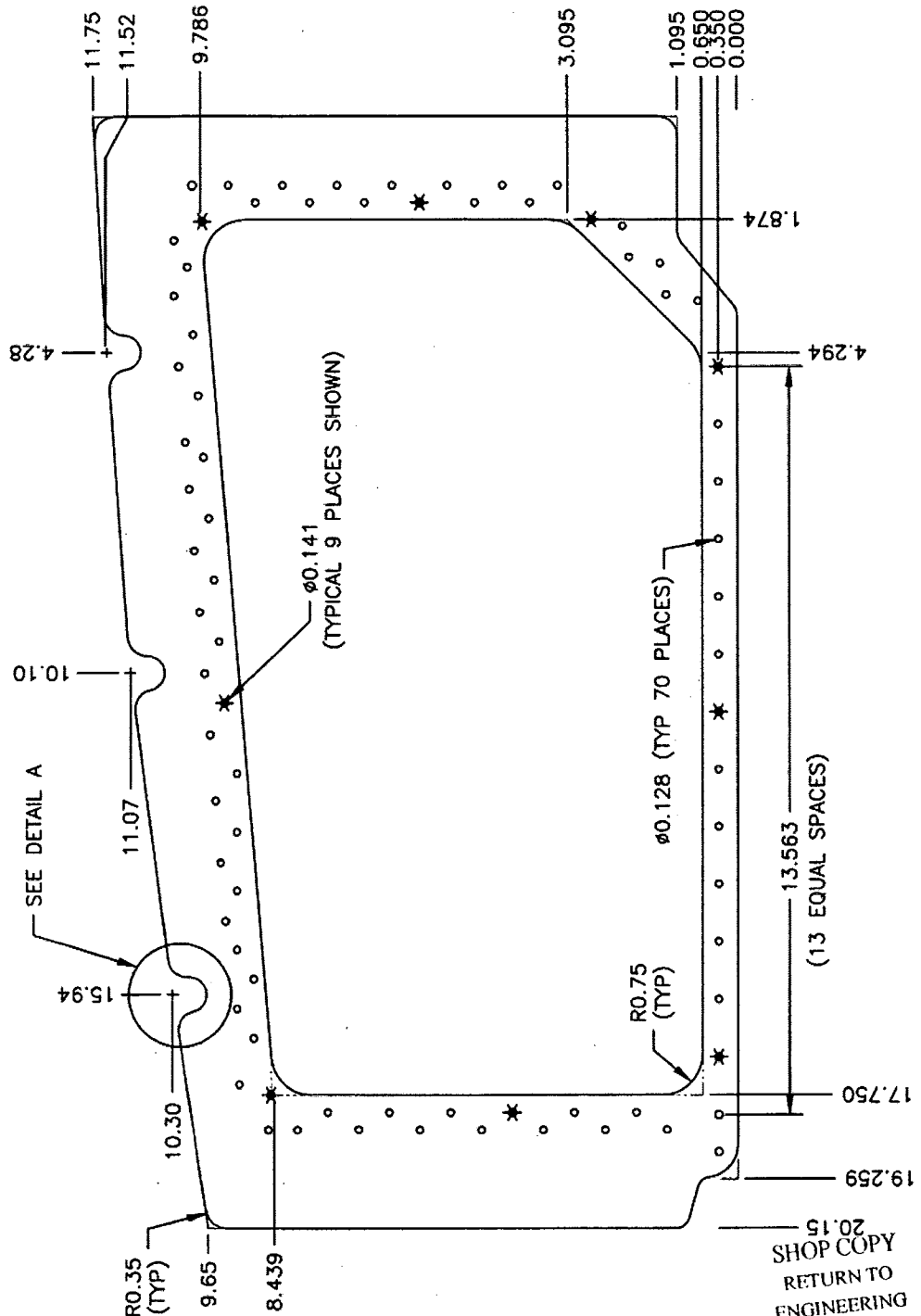
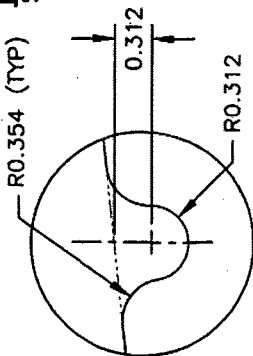
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>op</i>	DRAWN BY <i>op</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3293	REV. A SHEET 1 OF 1
DATE 04.06.28		TITLE DOUBLER	SCALE 1:3
A	04.06.28	NEW ISSUE	

D3293-1 DOUBLER
MAKE PER DRAWING FILE "D3293-A1.DWG"
CHECK PER TEMPLATE D3293-1T1
DIMENSIONS SHOWN FOR REFERENCE ONLY
MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.080 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT BLACK SANDEX (REF. 4.3.5.7) PER
DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
04.07.12**DETAIL A**
SCALE 2:3SHOP COPY
RETURN TO
ENGINEERING

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

UNCONTROLLED COPY
SUBMIT AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 4854